

# Work Order ID 81558

**\*81558\***

Page 1

March 15, 2012 10:59:00 AM

Item ID: D2230-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug

Start Date: 3/15/12 Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Approvals: Process Plan: *CZ*

Date: *12/03/15* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: \_\_\_\_\_

*Cut @ meter*

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1 *Punch.*

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

Check for crack while loading into the machine.

2- deburr

*#2*

*P/O. 16451*

*issue P/O to meter*

*machine is per drawing D2230 REV.G*

*CZ 12/03/15*

*CZ 12/03/15 200*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name: Lug

Start Date: 3/15/12 Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120 *not*  
**\*120\***  
QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*rec'd + inspect for transit damage -  
attached c/c to W10*

*SP  
12-04-12*

130  
**\*130\***  
QC  
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*8/2/11/12*

*counts  
(x700)  
23/01/9*

150  
**\*150\***  
HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*(200) m-h  
12-4-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 3

March 15, 2012 10:59:00 AM

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Stop

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Item Name: Lug

Start Date: 3/15/12

Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 4/06/12

Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

200  $\phi$  BL 24-18

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*170\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

200 X  $\phi$  M-L 12/04/18

m121134

3-30  
3200F  
4-00

200  $\phi$  BL 24-19

Work Order ID 81558

\*81558\*

Page 4

March 15, 2012 10:59:00 AM

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\*200\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: 480

0.00

\*190\*

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

200

12/4/19

MLJ 12/04/19

12-04-19

# Picklist Print

March 15, 2012 10:59:00 AM

Work Order ID: 81558

Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 3/15/12

Required Date: 4/06/12

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder  
coatEC  
BY:EC  
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		200			
LUG													
D2423		Manufactured	No			100	f	321.6600	0.0683	14.378947			
Lug Extrusion													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT006		321.66							
				43722		161.5							
				45800		1							
				68331		159.16							

SP  
12-04-12  
14.32 CD 12/03/15

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

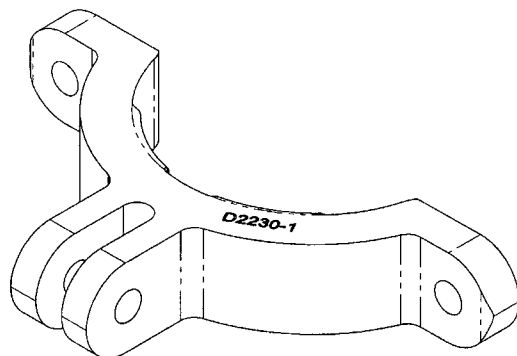
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

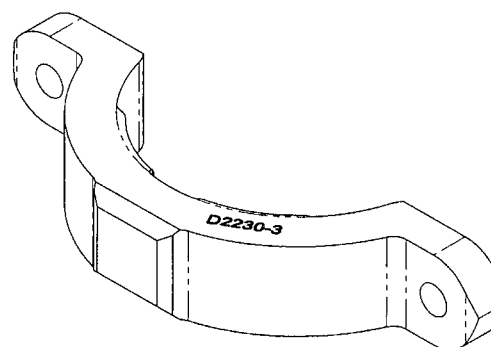
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

CL12103115  
W10: 81558

**RELEASED**  
01/06/25 AMP

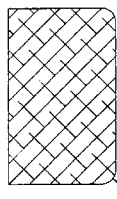


**NOTES:**

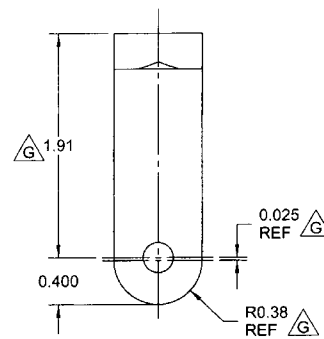
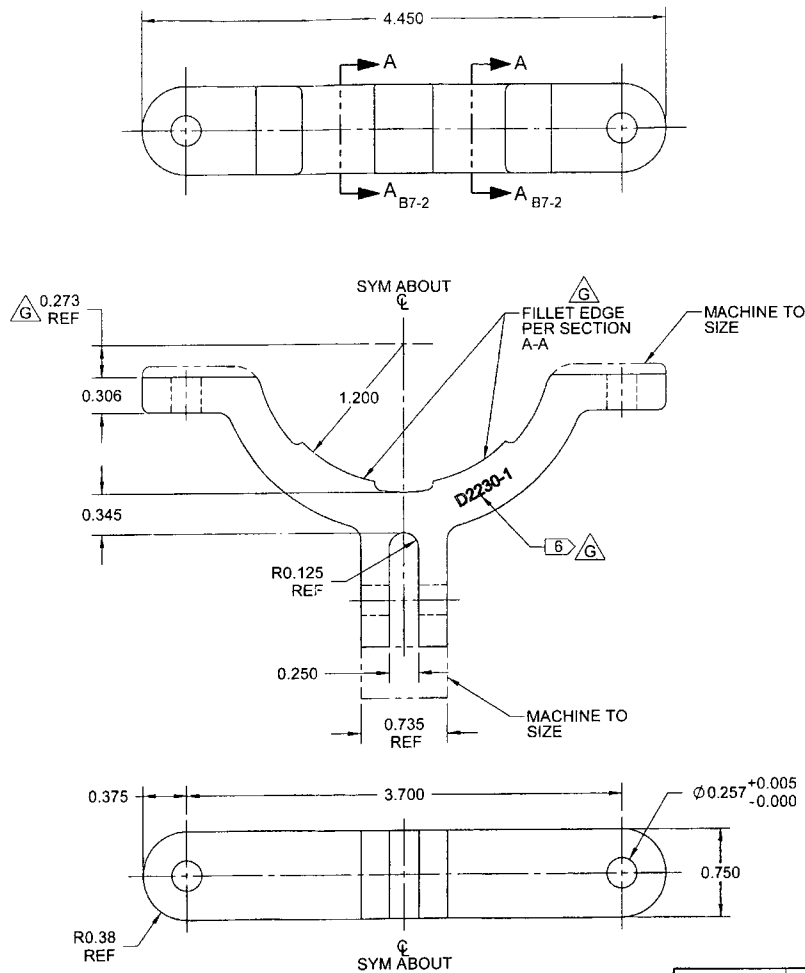
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

**SECTION A-A** D4-2  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL

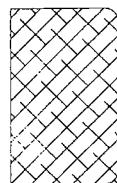


**D2230-1 MOUNTING LUG**

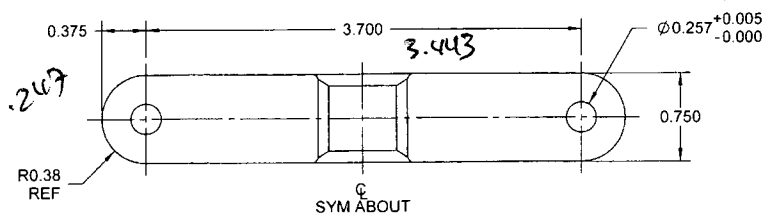
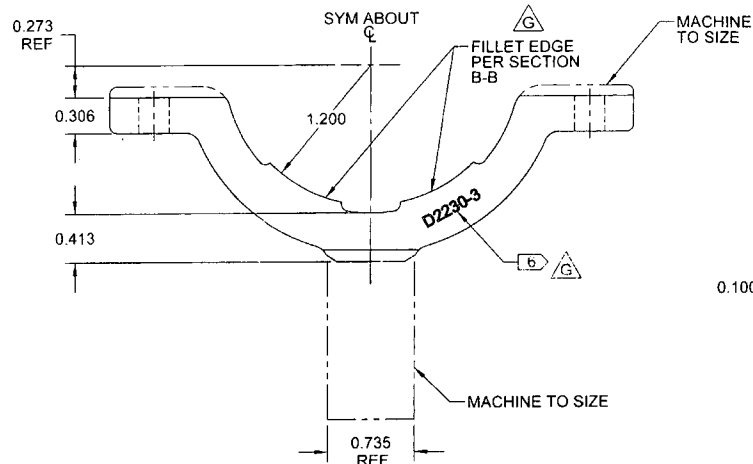
**RELEASED**  
09/06/25/10

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG</b>	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**SECTION B-B** D4-3  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/2014

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG</b>	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

60

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16451

Purchase Order Date 3/15/12

PO Print Date 3/15/12

Page Number 1 of 2

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC.  
30 TERRY FOX DRIVE PO BOX 781  
WANKLEEK HILL, ON K0B 1R0

Company Name  
Vendor Phone 613 678 3957  
Vendor Fax 613 678 3956  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
3/15/12

Line Nbr	Reference - Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-1P	CROSTUBE LUG	3/30/12 Yes	✓ 40.00 Each	Dart Truck 102 3/23	\$31.5500	\$1,262.00
		Special Inst:	AS PER DWG D3910 REV. B B81474				
2	D2230-3P	LUG	4/05/12 Yes	✓ 200.00 Each	Dart Truck	\$13.6000	\$2,720.00
		Special Inst:	AS PER DWG D2230 REV. G B81558				
3	D4091-1P	LUG	4/09/12 Yes	✓ 30.00 Each	Dart Truck 800-05-37	\$26.9500	\$808.50
		Special Inst:	AS PER DWG D4091 REV. A B81461				
4	D4091-3P	Crosstube Lug	4/12/12 Yes	✓ 40.00 Each	Dart Truck 102 3/23	\$31.5500	\$1,262.00

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Page Nbr

Charge Date: 3/15/12



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18654  
**Date:** Apr 09, 2012  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> PO16451	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	Each	40		
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	Each	200	200	
D4091-1 Lug as per drawing D4091 Rev.AB81461	Each	30		
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	Each	40		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug	16451

MATERIAL: supplied by DART B68331

*8176446*

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, April 11, 2012